

Date: Wednesday, 30/07/2008 5:29:51 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT FACING SEAT ASS'Y LH
Job Number :	40821		
Estimate Number :	13306		
P.O. Number :		Part Number :	D412769043
This Issue :	30/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D412-769-1 REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :	40820	Drawing Revision :	B
	Type :	Material :	
	SMALL /MED FAB	Due Date :	15/08/2008
Written By :		Qty:	1
Checked & Approved By :	<u>JUL 08-7-31</u>	Um:	Each
Comment :	Est rev A 08-05-12 new issue DD verified by:EC Est Rev:B 08-07-17 revB as per dwg DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0	D3782045	Back Leg Assembly
-----	----------	-------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Back Leg Assembly

batch: B40873-3

FF 08/08/27

3.0	D3782041	Front Inboard Leg Assembly
-----	----------	----------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Front Inboard Leg Assembly

batch: B40870

SP

4.0	D3782043	Front Outboard Leg Assembly, LH
-----	----------	---------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Front Outboard Leg Assembly, LH

batch: B40871

SP

5.0	D3783041	Lateral Brace Assembly
-----	----------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lateral Brace Assembly

batch: B40874

8/8/26

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 30/07/2008 5:29:51 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 40821

Part Number: D412769043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D3783043	Longitudinal Brace Assembly
-----	----------	-----------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Longitudinal Brace Assembly
batch: B40875

sq

7.0	D3783045	Angle Brace Assembly
-----	----------	----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Angle Brace Assembly
batch: B40876

S/S 08/08/29

Q

8.0	D3784041	Seat Support Assembly, Center
-----	----------	-------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Support Assembly, Center
batch: B40877

~~S/S 08/08/29~~ sq

9.0	D3784043	Seat Support Assembly, LH
-----	----------	---------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Support Assembly, LH
batch: B40878

sq

10.0	D3784044	Seat Support Assembly, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Support Assembly, RH
batch: B40879

sq

11.0	D37661	Front Rail, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Front Rail
batch: B40863

sq

12.0	D37663	Rear Rail
------	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Rear Rail
batch: B40865

8/8/26

sq

Dart Aerospace Ltd

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Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 40821

Part Number: D412769043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	D37671	Upper Rail
------	--------	------------

4



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

ALODINE

Upper Rail

batch: B240866

sq

14.0	D37921	Seat Belt Eye Bolt
------	--------	--------------------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Seat Belt Eye Bolt

batch: B240999 ①

B241521 ②

sq

15.0	AN415A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M104746

sq

16.0	AN45 13A	EYE BOLT
------	----------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

EYE BOLT

batch: M109013

sq

17.0	AN510A	Bolt
------	--------	------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M108471

sq

18.0	AN513A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M108167

81867

sq

19.0	AN960JD10	Washer
------	-----------	--------



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Washer

batch: M109059

(or NAS1149D0363J) batch: M109059

FF 08/08/27

①

W/O:		WORK ORDER CHANGES					
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASSY LH

Job Number: 40821

Part Number: D412769043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M108161

(or NAS1149D0463J) batch: _____

SP

21.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

batch: M108678

(or NAS1149D0568J) batch: _____

SP

22.0	AN52510R24	Screw
------	------------	-------



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Screw

batch: M108270

SP

23.0	MS21042L3	Nut
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Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Nut

batch: M108701

SP

24.0	MS21042L4	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M107499

SP

25.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M108171

8/8/27

SP

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Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 40821

Part Number: D412769043

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-1

FF 08/08/27 (1)

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/27 (1)

28.0

POWDER COATING

POWDER COATING



M 106 442



(1)

Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-041

2- Powder coat remainig of assembly grey as per dwg D412-769-1

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

10:15

OVEN TEMPERATURE:

320 °C

FINISH TIME:

10:45

M-L 08/08/28

29.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-28 (1)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0

D37751

Guard



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Guard

batch: B 40658

SB 08/08/29 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 40821

Part Number: D412769043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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32.0	D37741	Seat Bottom, LH/RH
------	--------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Bottom, LH

batch: B40867

SB 08/08/29 ①

33.0	D37743	Seat Back, LH/RH
------	--------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Bottom, LH

batch: B40868

SB

34.0	AN525 10R22	Screw
------	-------------	-------



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Screw

batch: M107936

SB

35.0	AN960JD10L	Washer
------	------------	--------



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Washer

batch: M105793

(or NAS1149D0332J) batch: _____

SB

36.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Nut

batch: M108701

SB

37.0	AN35A	Bolt
------	-------	------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M100188

SB 08/08/29 ①

38.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- install remaining parts as per dwg D412-769-1

FF 08/08/29 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Process Sheet

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Drawing Name: AFT FACING SEAT ASSY LH

Job Number: 40821

Part Number: D412769043

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

39.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/29 (X)

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP40805

SS 08/08/29 (X)

41.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
H 08/08/29

Job Completion



MF 08-08-29

Dart Aerospace Ltd

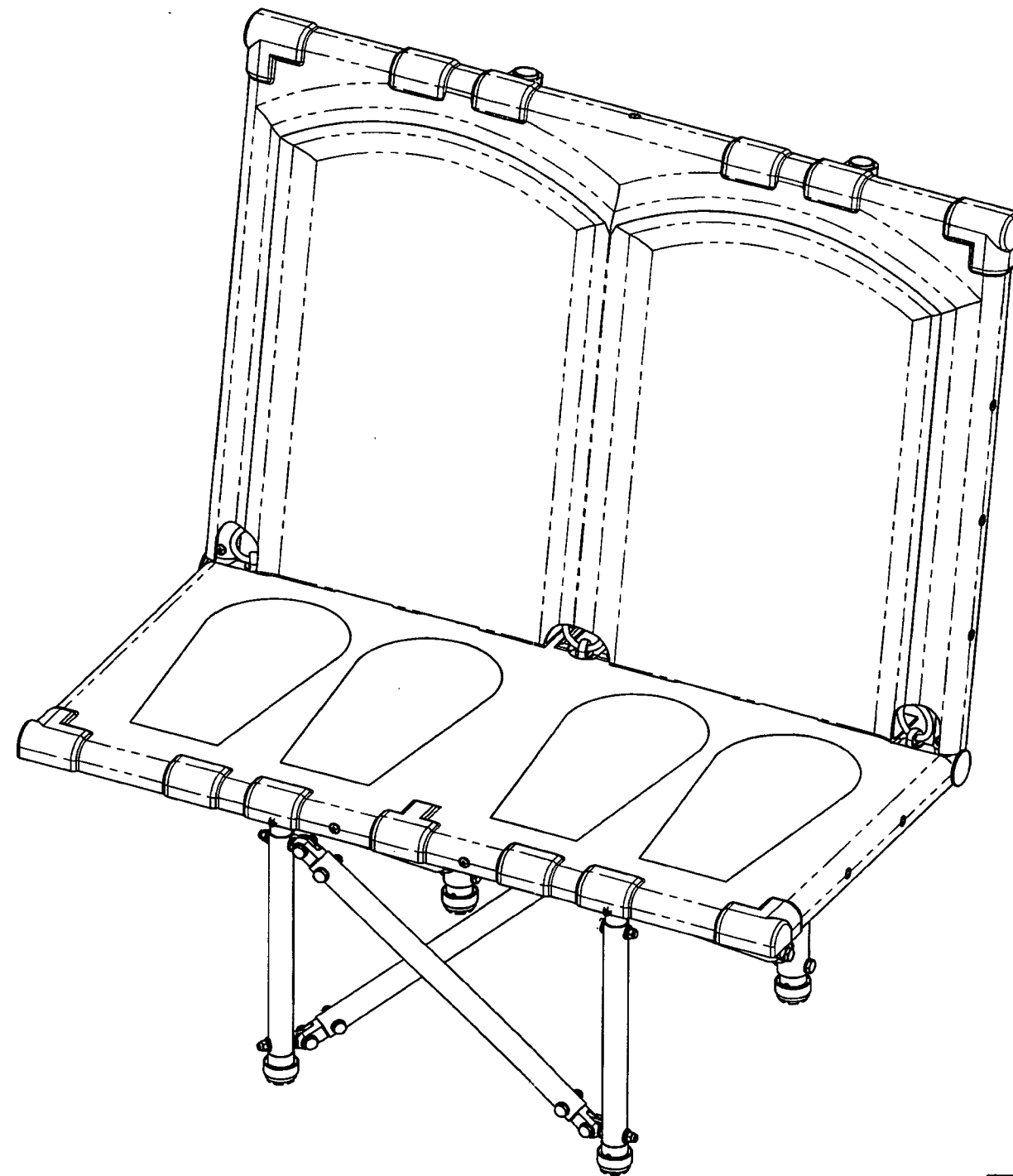
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D412-769-043 AFT FACING SEAT ASSY, LH

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WORK ORDER
NO. 40821

RELEASED
580709

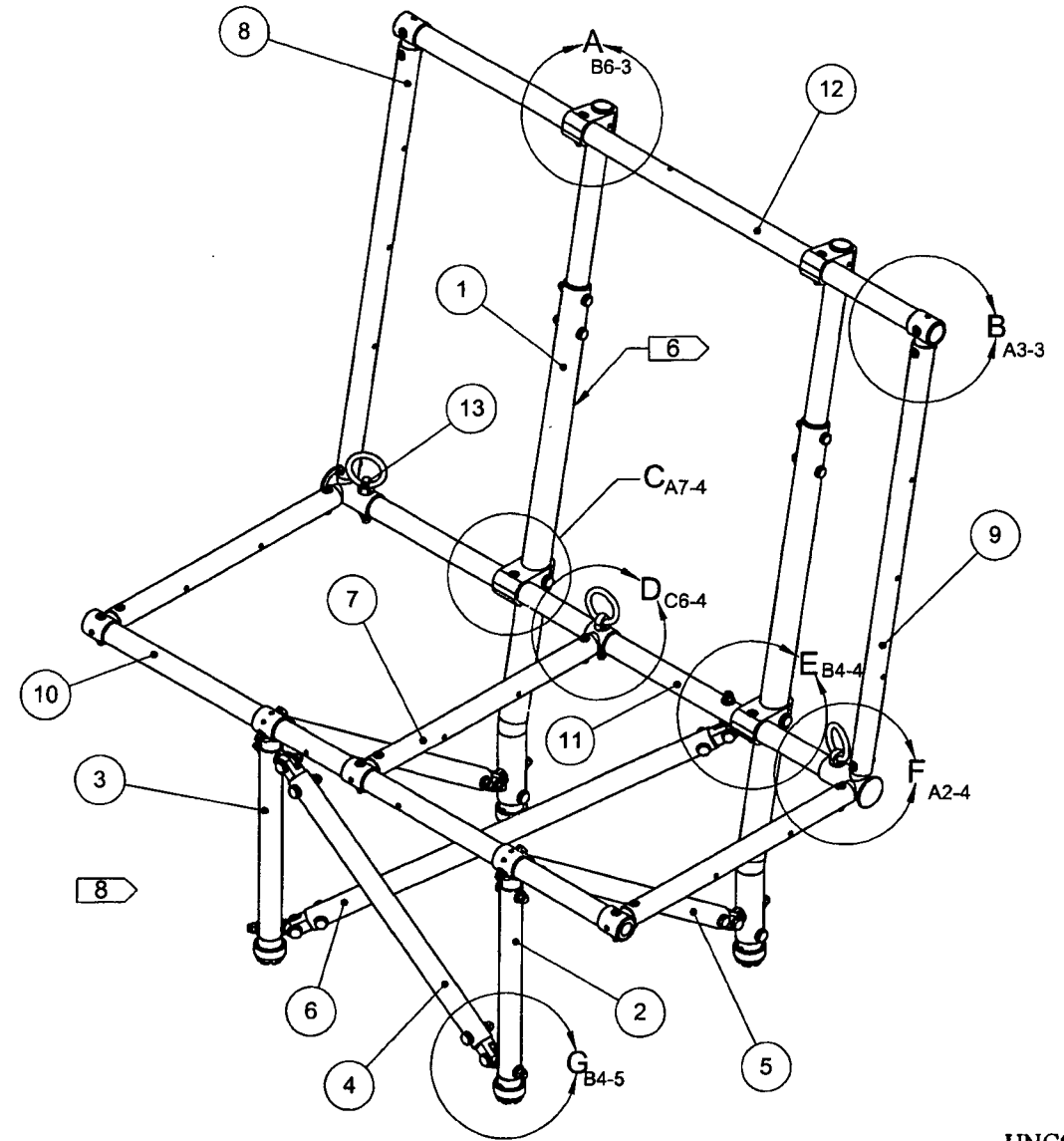
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A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D412-769-1	SHEET 1 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT FACING SEAT ASSY, LH	NTS
DATE	08.06.25	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-043	FRONT OUTBOARD LEG ASSY, LH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D3766-1	FRONT RAIL, LH	1
11	D3766-3	REAR RAIL	1
12	D3767-1	UPPER RAIL	1
13	D3792-1	SEAT BELT EYE BOLT	3
14	D3775-1	GUARD	2
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	AN3-5A	BOLT	6
18	AN4-15A	BOLT	2
19	AN45-13A	EYE BOLT	1
20	AN5-10A	BOLT	6
21	AN5-13A	BOLT	2
22	AN525-10R22	SCREW	13
23	AN525-10R24	SCREW	9
24	MS21042L3	NUT	28
25	MS21042L4	NUT	2
26	MS21042L5	NUT	12
27	NAS1149D0332J	WASHER (AN960JD10L)	13
28	NAS1149D0363J	WASHER (AN960JD10)	21
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	20

B
B

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLED SEAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1/-3). MASK FRONT LEGS PRIOR TO POWDER COAT.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
- 7) WEIGHT: 30.0 lbs
- 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

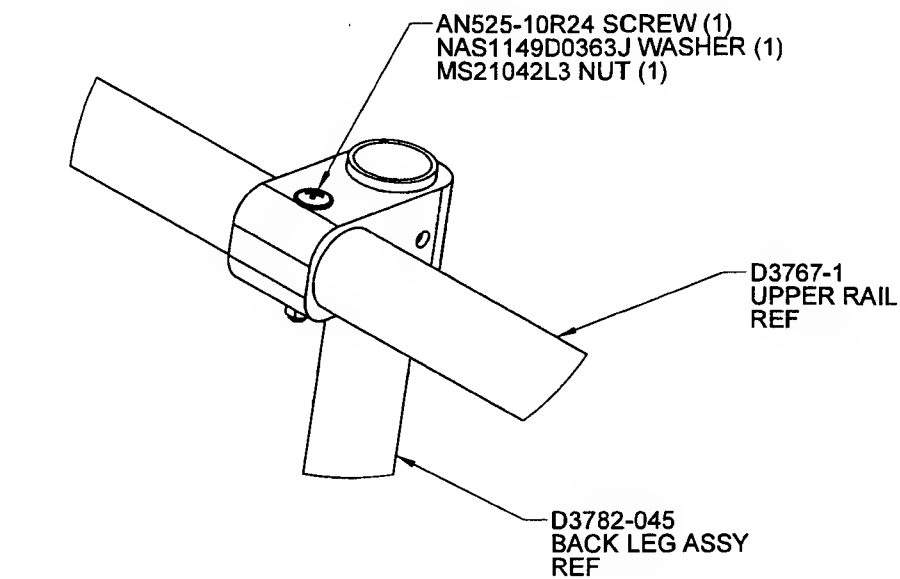


D412-769-043 AFT FACING SEAT ASSY, LH

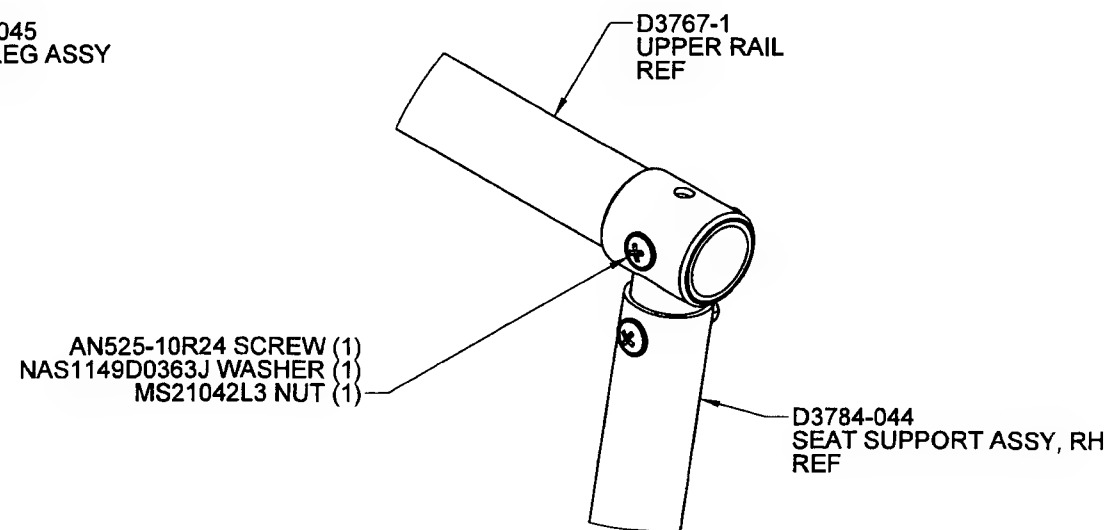
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MFG. APPR.		D412-769-1	SHEET 2 OF 7
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DETAIL A D2-2
UPPER RAIL TO BACK LEG ATTACHMENT
 2 PL



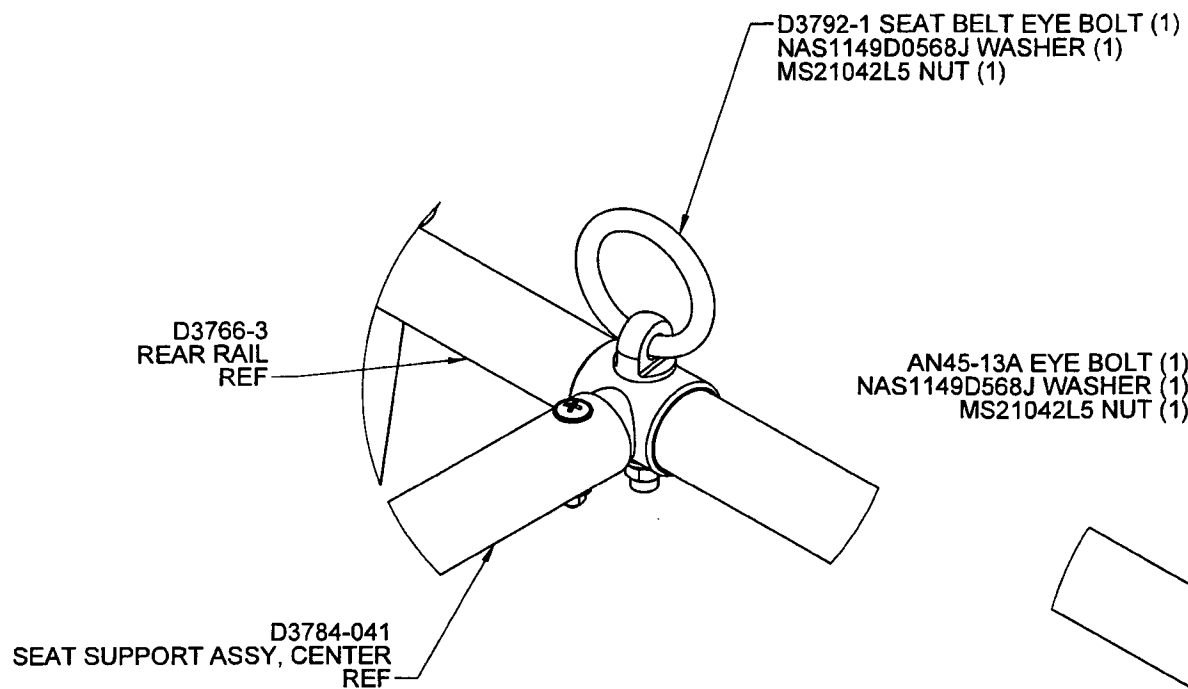
DETAIL B C1-2
SEAT SUPPORT END ATTACHMENT
 5 PL

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 08-07-09

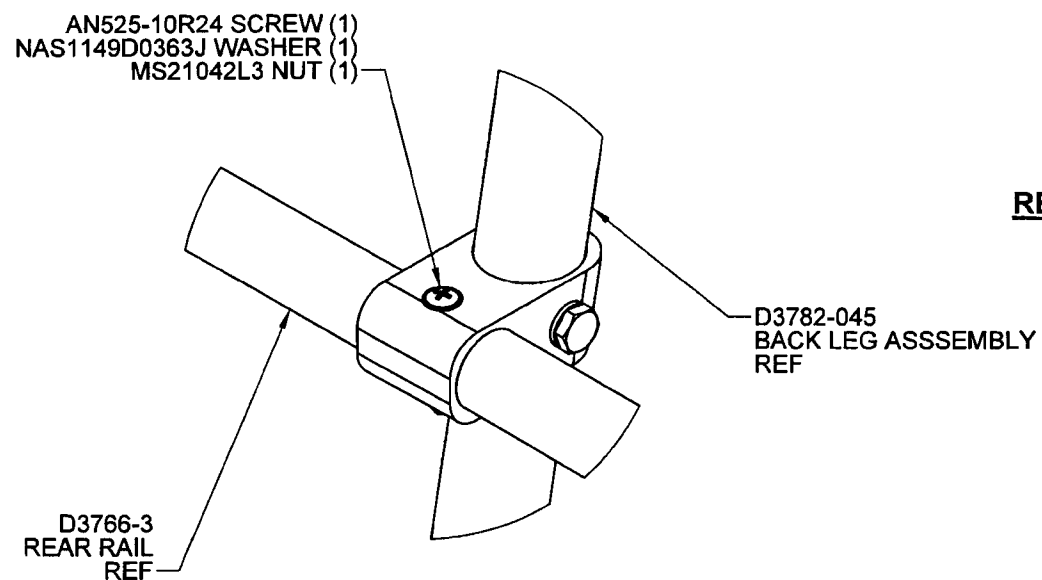
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MFG. APPR.	<i>[Signature]</i>	D412-769-1	SHEET 3 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT FACING SEAT ASSY, LH	NTS
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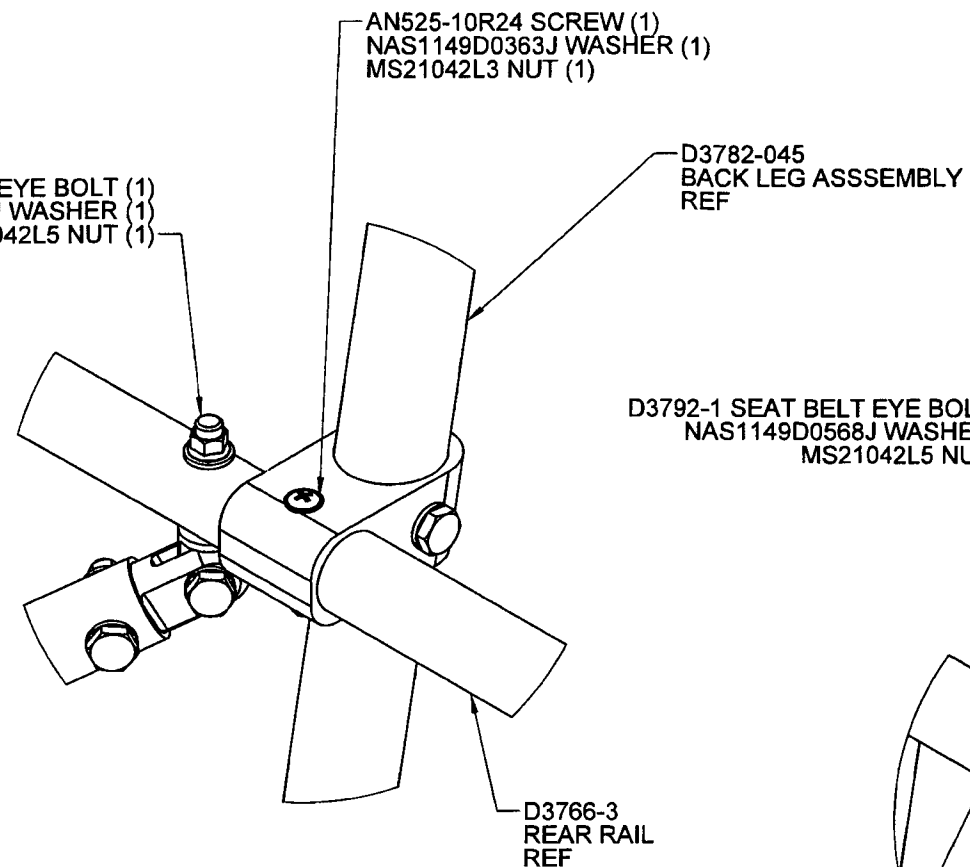
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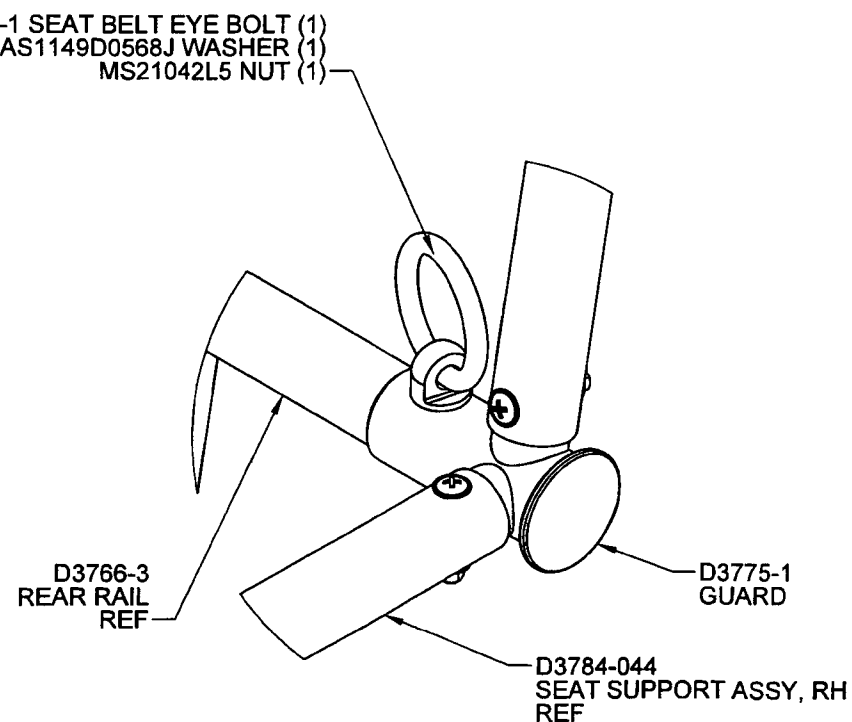
DETAIL D C2-2
SEAT SUPPORT ASSY, CENTER ATTACHMENT



DETAIL C C2-2
REAR RAIL TO BACK LEG ATTACHMENT



DETAIL E C1-2
REAR RAIL TO BACK LEG ATTACHMENT



DETAIL F B1-2
SEAT SUPPORT ATTACHMENT
2 PL

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08.06.25

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MFG. APPR.		D412-769-1	SHEET 4 OF 7
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, LH	NTS
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8 7 6 5 4 3 2 1

8

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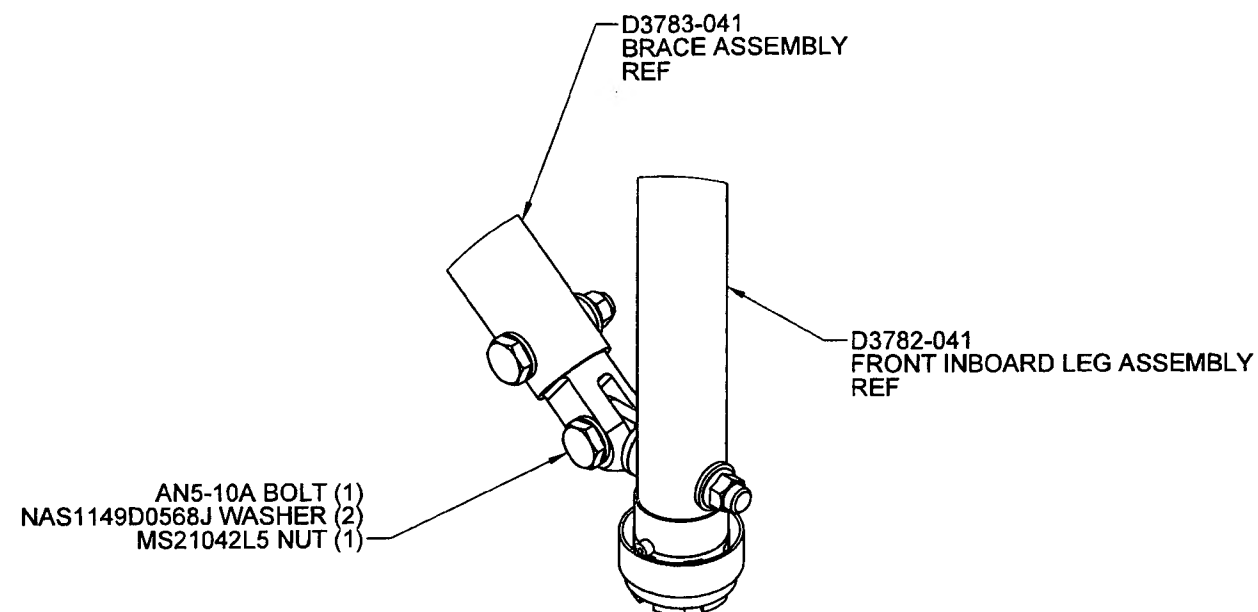
C

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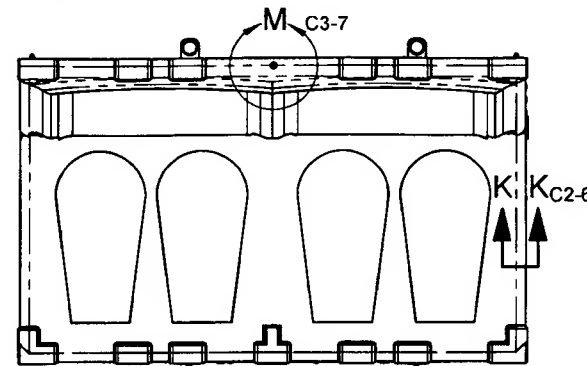
DETAIL G_{B2-2}
BRACE ATTACHMENT

6 PL

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WORK ORDER
NO. 40821

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08-07-07/11/12

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D412-769-1	SHEET 5 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	AFT FACING SEAT ASSY, LH	NTS
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AN525-10R22 SCREW (1)
NAS1149D0332J WASHER (1)
MS21042L3 NUT (1)
3 PL PER SIDE

D3784-044
SEAT SUPPORT, RH
REF

AN525-10R22 SCREW (1)
NAS1149D0332J WASHER (1)
MS21042L3 NUT (1)
2 PL PER SIDE

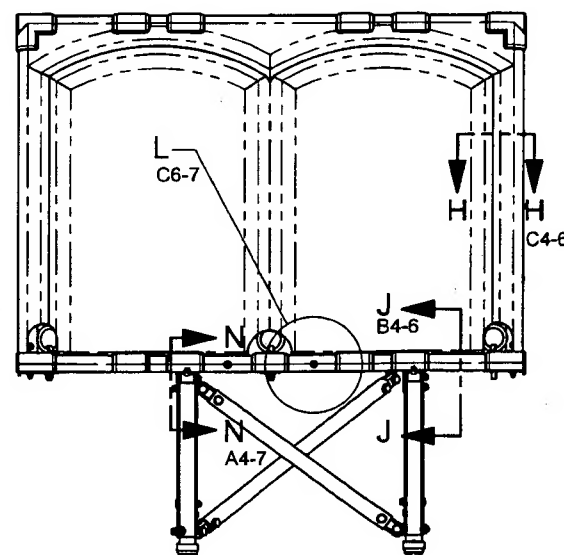
D3774-1
SEAT BOTTOM
REF

D3774-3
SEAT BACK
REF

D3784-044
SEAT SUPPORT, RH
REF

SECTION H-H B7-6

SECTION K-K D7-6



D3766-1
FRONT RAIL
REF

SECTION J-J A7-6

D3774-3
SEAT BACK
REF

D3774-1
SEAT BOTTOM
REF





D3766-3
REAR RAIL
REF

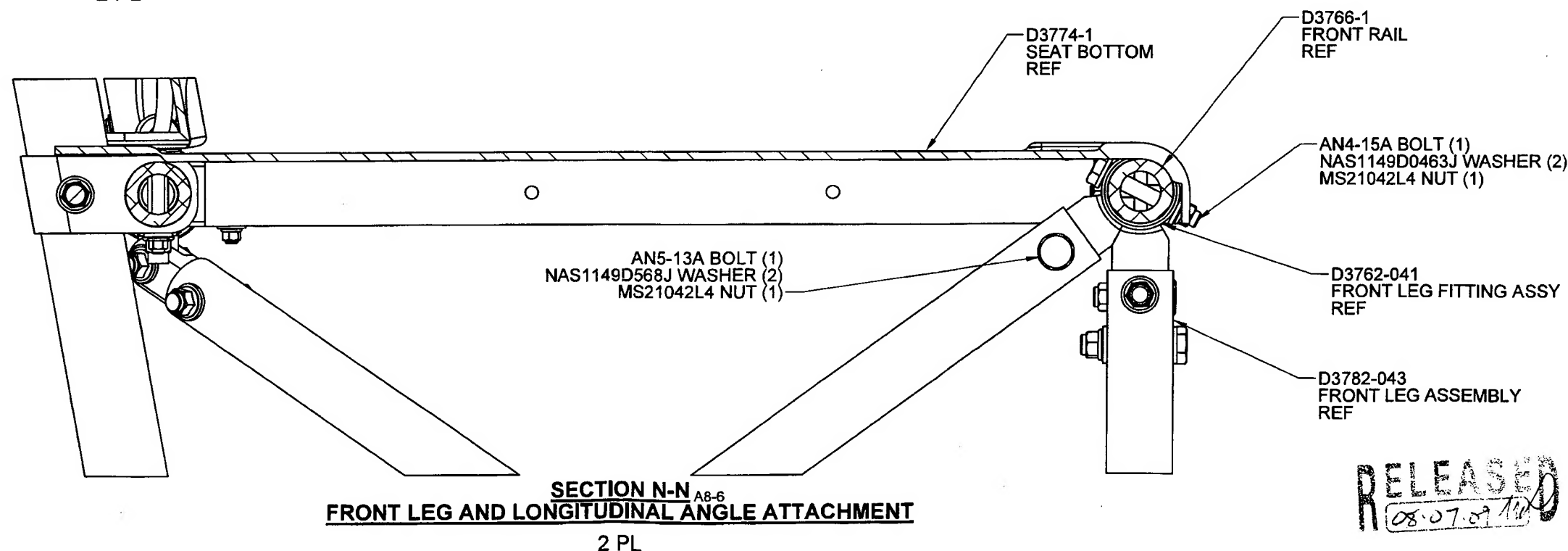
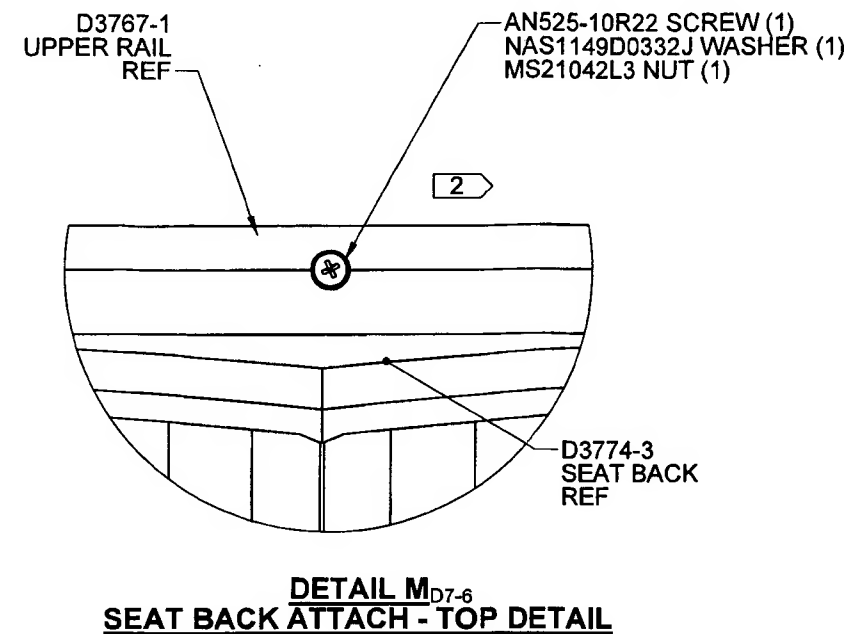
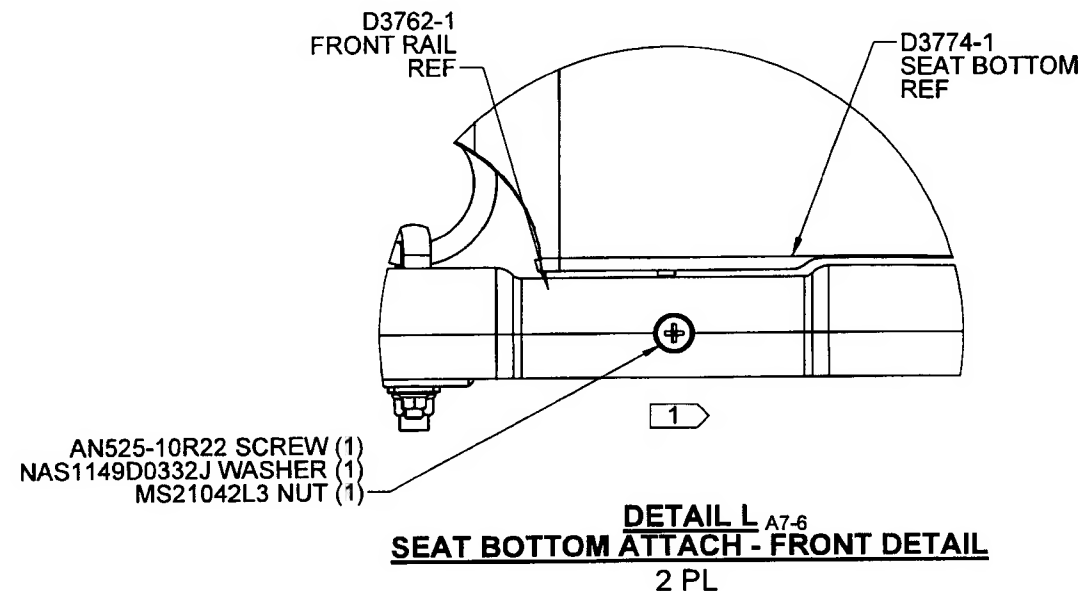
AN3-5A BOLT (1)
NAS1149D0363J WASHER (2)
MS21042L3 NUT (1)
6 PL

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NO. 40821

- NOTES:**
1) TRANSFER DRILL $\varnothing 0.201$ FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BACK (D3774-3) - 3 PL/SIDE
2) TRANSFER DRILL $\varnothing 0.201$ FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BOTTOM (D3774-1) - 2 PL/SIDE
3) TRANSFER DRILL $\varnothing 0.201$ FROM SEAT BOTTOM (D3774-1) TO SEAT BACK (D3774-3) - 6 PL

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D412-769-1	SHEET 6 OF 7
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DE APPR.		AFT FACING SEAT ASSY, LH	NTS
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NOTES:
1) TRANSFER DRILL $\varnothing 0.201$ FROM FRONT RAIL (D3766-1) TO SEAT BOTTOM (D3774-1) - 2 PL
2) TRANSFER DRILL $\varnothing 0.201$ FROM UPPER RAIL (D3767-1) TO SEAT BACK (D3774-3) - 1 PL

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D412-769-1	SHEET 7 OF 7
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DE APPR.		AFT FACING SEAT ASSY, LH	NTS
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